



Dart Hawkesbury
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D4635-144
Job Sheet 167086-B



Part No: D4635-144

Job Qty: 1 ea

Part Name: Aft Ceiling Replacement Panel Assembly, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	
100	HandThermo	1 pcs		11/9/17	0.00	1.16	HandFinish4	
110	Small Fab	1 pcs		11/10/17	0.00	1.57	Small Fab	
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4635-144 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M

3950 edge sealer(see note 9) Batch: _____

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation <i>Not bonded - 5022644</i>	D4635-4 5022733	1	2	0	0
	D4669-1	1	27	0	0
	D4695-4 5022324	1	2	0	0
	D4732-11 5022732	1	5	0	0
	D4732-39 5022730	1	6	0	0
	D4732-41 5022729	1	6	0	0
	D5022-5 5022728	1	2	0	0

Part Specifications

Specifications could not be found.

Plex 10/24/17 11:07 AM dart.poulin.mario

DQA:

Date:

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

Date : _____

Description Work _____

DISPOSITION

Rework ☐
Scrap ☐Skid-tube ☐
Machining ☐

AGAINST DEPARTMENT/PROCESS

Cross tube ☐
Small Fab ☐Water Jet ☐
Prod. Eng. Coord. ☐
Packaging ☐
Supplier ☐Engineering ☐
Quality ☐
Other ☐

S027235

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MRB (QSI042) Approval

Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval

Aft Ceiling Replacement Panel Assembly, RH

PART NO: D4635 – 144
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 12/28/17
Job No: 167086 – B

Root Cause

Environment	☐	No Re-verification
Design	☐	Operator
Doc/Data	☐	Offset/Setup
Equip/Tooling	☐	Supplier
Handling/Pre	☐	Training
Material	☐	Use for Testing
Internal Transport	☐	Poor Information
Tribal Knowledge	☐	Rushing
LOA	☐	Product Improvement
Substation	☐	Process Improvement
Past Expiry Date	☐	Manufacturing Process
Misidentified	☐	Past Due

Bending
Centre Not Concentric
Cracks
Crimp/Kink/Ripple/Wave
Cuffs
Crushing
Heat Treat
Wave/Twist in Tube
Marks/Chatter

Set-up
BOM/Route
Broken/Damage/Defect
Inspection Incomplete/Unqualified
Contamination
Countersink
Cut Too Short
Instructions Incomplete/Unclear
Drill Holes

Tool/Program
Grain
Weld
Wrong Stock Pulled
Out of Sequence
Off-set
Mislabeled
Fit/Function
Misaligned/off center

Positioned Wrong
Outside Dimensions
Over/Under tolerance
Part Incorrect
Part Lost/Missing
Part Moved
Drawing
Finish
Misread
Turning Sequence

OTHER :